

Work Order ID 74807

74807

Page 1

October 6, 2011 2:35:54 PM

Item ID: D4021-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hoop
 Start Date: 10/06/11 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/14/11 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4021	B

100		0.00
-----	--	------

100
 Waterjet
 FLOW CNC Waterjet

Memo
 Cut as per dwg D4021
 Prog Rev: B
 Dwg Rev: B
 Deburr as required

0.00

Bill-10-7

GP 11/10/10

(10)

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110
 QC
 Quality Control

Memo

0.00

Bill-10-7

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>ALL</u>			
130 *130* Small Fab Small Fab	Memo 1- make radius as per dwg 2- deburr	0.00 0.00							<u>8/11/12/26</u> (10)
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>ALL</u>			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150	<i>Back of coll</i>								
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

11/10/27 *10x*

11/10/31 *ME* *11-10-31*

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Picklist Print

October 6, 2011 2:36:00 PM

Page 1

Work Order ID: 74807

74807

Parent Item: D4021-7

D4021-7

Parent Item Name: Hoop

Start Date: 10/06/11

Required Date: 10/14/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.625X3.000

Purchased

No

100

f

26.0560

0.4166

2.631158

4.5

M304B0 625X3 000

**

BK-10-7

304 BAR .625 X 3.00

Location

Loc Qty

Loc Code

MAT050

26.056

117130

0.55

118900

0.166

118917

25.34

118917

10

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DART AEROSPACE LTD		Work Order:	74807
Description: Hoop		Part Number:	D4021-7
Inspection Dwg: D4021	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: B	Audited by: S.	Preliminary Approval: N/A
Date: 11-10-7	Date: 11/10/26	Date: N/A

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.08.18	Dimensions revised per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

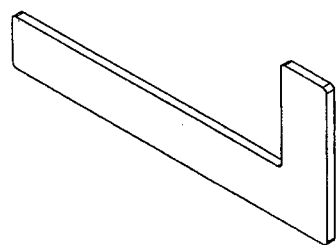
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

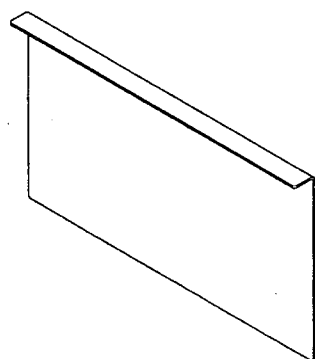
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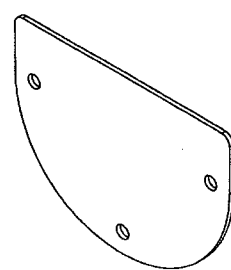
8 7 6 5 4 3 2 1



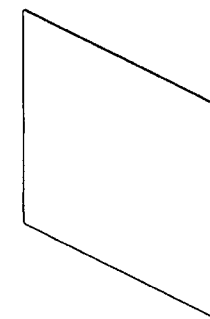
D4021-1 HANDLE PLATE



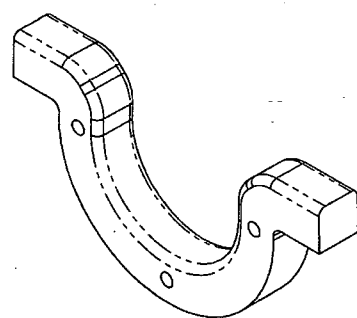
D4021-3 DATA PLATE



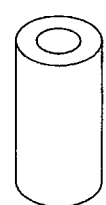
D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



D4021-9 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 348.07 M.C.D

11/10/06

RELEASED
2010-04-14

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4021 REV. B SHEET 1 OF 3 TITLE MISC PARTS - 350 BASKET SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	JPH		
CHECKED	[Signature]		
MFG. APPR.	[Signature]		
APPROVED	[Signature]		
DE APPR.	[Signature]		
DATE	10.04.06		

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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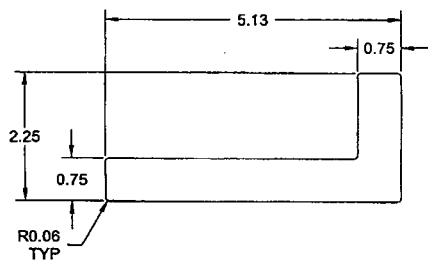
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

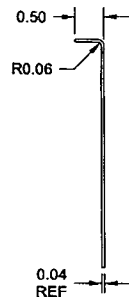
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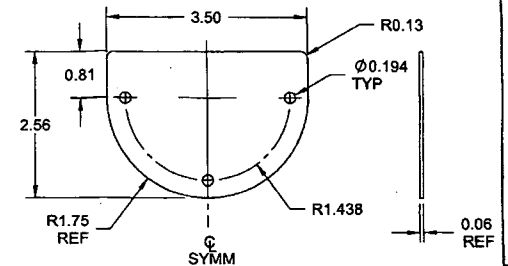
74807



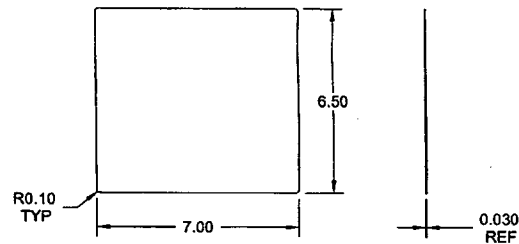
D4021-1 HANDLE PLATE



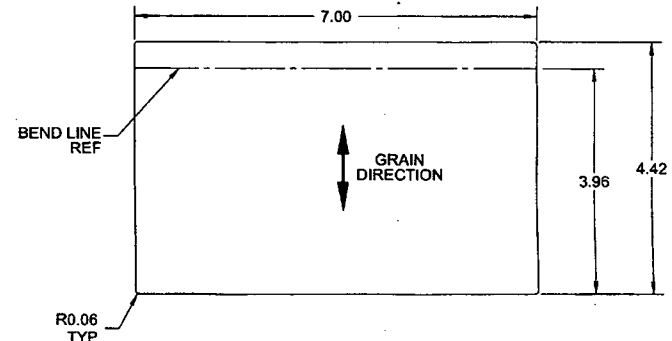
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-3F DATA PLATE
FLAT PATTERN

- NOTES:**
- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
 - 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
 - 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
 - 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- FINISH:** -1/-3/-11: NONE
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs
-5: 0.14 lbs -11: 0.39 lbs

RELEASED
2010-04-16
NWP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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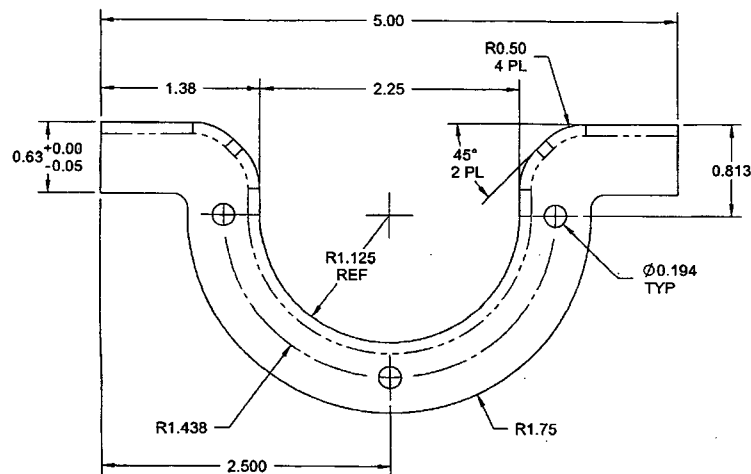
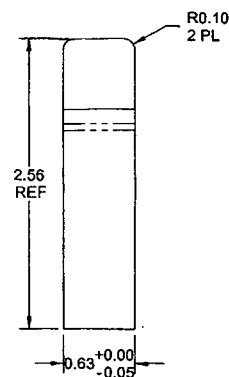
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NOTE: Date & initial all entries

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**D4021-7 HOOP****D4021-9 BUSHING****NOTES:**

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

RELEASED
2010-04-14
NR

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
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